

Date: Wednesday, 25/06/2008 9:58:19 AM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LOCKING SLEEVE
Job Number : 40023	
Estimate Number : 12062	
P.O. Number :	Part Number : PB6743001137
This Issue : 25/06/2008 S.O. No. :	Drawing Number : B6743001 PAGE35
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B1
Previous Run : 40023	Material :
Written By : <u>[Signature]</u>	Due Date : 02/07/2008 Qty: 10 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est. A 05.08.29 New issue KJ/JLM	
Est Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 TUBE
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Comment: Qty.: 0.1860 f(s)/Unit Total : 1.8596 f(s)

6061T6 TUBE

Turn as per Dwg B67-43001

Dwg Rev: _____

Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) Ø1.00 x .065" wall tubing

(M6061T6T1.000W.065)

Identify for B67-43001-137

Batch: 14108380

Deburr

RD 08/06/28

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE

1- Turn as per Folio FA Rev: B1 & Dwg B67-43001-1 Rev: B1

2-Deburr per dwg B67-43001-1

RD 08/06/28

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RD 08/06/29

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

RD 08/06/29

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOCKING SLEEVE

Job Number: 40023

Part Number: PB6743001137

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(10X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-h 06/07/02

6.0

POWDER COATING

POWDER COATING



m102316

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask inside sleeve

(10X)

START TIME:

10:30

OVEN TEMPERATURE:

320

FINISH TIME:

11:00

BL / 217

08/07/00

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



22

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-10

(X10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Dat F*

mf 08-07-14

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-14

RELEASED
#06.01.20

① -157 TUBE

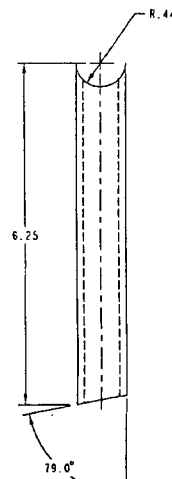
MATL: .875 OD X .125 WALL, 6061-T6, QQ-A-200/8
SCALE 1.000

② -131 TUBE END CAP

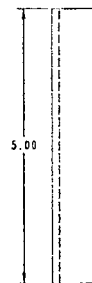
MATL: .125 THK, 6061-T6, QQ-A-250/11
SCALE 2.000

① -137 LOCKING SLEEVE

MATL: 1.00 O/D X .065 WALL, 6061-T6, WH 1 700/6
SCALE 2.000



REFERENCE ONLY



① -127 HANDLE ARM

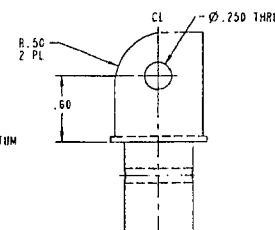
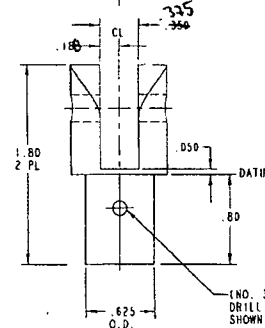
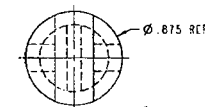
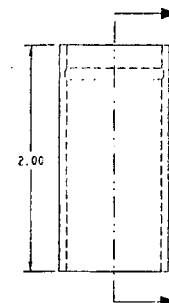
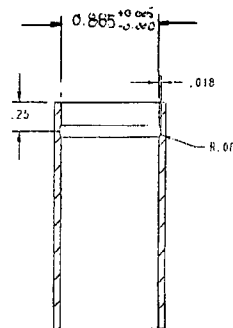
MATL: .875 OD X .125 WALL, 6061-T6, QQ-A-200/8
SCALE 1.000

① -129 TUBE HANDLE

MATL: .875 OD X .125 WALL 6061-T6, QQ-A-200/8
SCALE 1.000

① -133 CLEVIS

MATL: .875 RND, 6061-T6, QQ-A-200/8
SCALE 2.000



(IND. 30 (Ø.128) THRU
DRILL AT INSTALLATION,
SHOWN HERE FOR REF.)

PREMIER AVIATION, INC.
8000 Aviation Parkway, Grand Prairie, Texas 75051
DATE: 08/08/88 BY: B67-43001 REV: 6A
SHEET: 35 OF 45

ORIGINAL

